Date:

Wednesday, 12/13/2006 2:47:05 PM

User:

Kim Johnston

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 29931

**Estimate Number** 

: 11917

P.O. Number

· HA

: 12/13/2006 This Issue

Prsht Rev. : NC. : MA First Issue

:NIA Previous Run

Written By

Checked & Approved By

Comment

Type

Re-format EC : Est B00.01.12

S.O. No. (1)

: SMALL /MED FAB

**Drawing Name** 

: TUBE ASSEMBLY

Part Number

Material Due Date

**Drawing Number** 

: D2003017 : UNDER REVIEW

**Project Number** 

: N/A

86.12.13 SEE NOTE ON DWG

: 1/10/2007

**Drawing Revision** 

Qty:

5 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6T0375W035

6061-T6 Tube .375 x.035W



Comment: Qty.:

1.4219 f(s)/Unit Total:

7.1096 f(s) Cut as per template D2003-017 (16.25" long)

Material:3/8"Æ x 0.035" wall 6061-T6 tubing

Batch: M 1793/

Cut: 17.0" long as per Dwg D2003 Material: M2650-6 Heat sleeve

(Batch: 1752)

FF. 07-01-03

ME

07-01-10

2.0

M26506

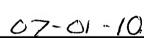
Firesleeve-crkl .375IDia



Comment: Qty.: 1.4200 f(s)/Unit

Total: Firesleeve-crkl .375IDia

₹,1000 f(s)



3.0

D2182

Heat Shrink





Comment: Qty.:

0.3750 f(s)/Unit

Total:

1.8750 f(s)

Pick:

1

Part Number Description D2182-045

Heat shrink

Batch

BALTERA

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES													
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
			(6)												
Dort No.	•	DAD #. Foult Cotomonic	<b>N</b> 1/	2D- V	(1) por		Data: Ø	2/3/12							

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section	Verification		Annroyal							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector						
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				, e6										

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:47:05 PM User: Kim Johnston **Process Sheet Drawing Name: TUBE ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Job Number: 29931 Part Number: D2003017 Job Number: Seq. #: Description: **Machine Or Operation:** Sleeve MS208196D 4.0 Comment: Qty.: 10.0000 Each(s) 2.0000 Each(s)/Unit Total: Sleeve Pick: Description Batch Qty Part Number m103044 2 MS20819-6D Sleeve AN8186D 5.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: \_5.0000 Each(s) 10.0 0 Nut Part Number Description Batch AN818-6D SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 07-01-03 Form tube as per template D2003-017 Assemble as per Dwg D2003 7.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 9.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion N 27.0/12

Form: rprocess

Page 2

Dart Ae	rospace	e Ltd		40				
W/O:			V	ORK ORDER CHANGE	ES			, ,
DATE	STEP	PR	OCEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		*						
		4						
				•				
					104	**		
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	lo DQA:	Date: _	
				÷	QA: N/	C Closed:	Date: _	
NCR:			WORK OR	DER NON-CONFORMAI	NCE (NCR)			
DATE	OTER	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
					-			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section B	Verification									
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto						
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NOTE: Date & initial all entries





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	1 1	EIM	D2003	SHEET 1 OF 2						
the second secon	DATEV		TITLE	SCALE						
	99.06	.08	206 CABIN HEATER	TUBE ASSEMBLIES NTS						
	Α	90.04.09	NEW ISSUE							
DELEASEN	В	99.06.08	UPDATE PER TEMP 0.025 TUBING NOW	LATES; ADD P/N'S; v 0.035 (TSR1049)						
NOTE: FLAT LENGTHS MAYBE UNDER REVIEW CB SHOP COPY  NOTE: FLAT LENGTHS MAYBE UNDER REVIEW  RETURN TO										

SHOP COPY

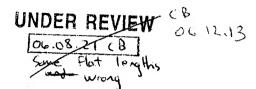
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- 1	ON CORR	ECT FLAT	LENG-	14	ш		Ä		/E		İ	UNCONIA	OLLLD O AMENDMENT
١			13		MS20819-8J SLEEVE		MS20819-8D SLEEVE		MS20819-6D SLEEVE			SUBJECT T	OANILITE
					7	_	Ä	<b>-</b>	).	<b> </b>			
ı			/E	CUT LENGTH OF TUBE <sup>2</sup>	S	AN818-8J NUT	O	AN818-8D NUT	30	NUT		WO	X ORDER 3331
١			EI_	57.	ထု်	Z	8	۵	9-6	a	1	17.9	3431
ļ			# E	N 20	119	<b>φ</b>	319	89	816	9-8		NO. <u></u>	
١			57 [5]	22	302	318	202	818	20	81			VENDOR OR
1			HEATSLEEVE LENGTH¹	2.4	AS:	Z	NS.	Z	MS	AN818-6D		MATERIAL 4/8/7	SPEC
1	P/N	TEMPLATE	<b>=</b> -	0	-						DESC.	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
ı	D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
ı	D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
	D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
	D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
1	D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
1	D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
-	D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
	D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
/	D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
	D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
	D2003-021	T2003-021	N/A	2.25			2	2		ļ	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
i	D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
1	D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
	D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
	D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
1	D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
	D2003-033	T2003-033	29.75	29.62	2	2			<u> </u>		TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
-	D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
	D2003-037	T2003-037	24.81	23.38	2	2				ļ	TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
	D2003-039	T2003-039	34.0	34.00	2	2		ļ	L	<u> </u>	TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
i	D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
	D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
	D2003-045	T2003-045	3.50	2.44	2	2		ļ	<u> </u>		TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
	D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
	D2003-049	T2003-049	33.2	34.00	2	2		<b> </b>	<b>-</b>		TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
	D2003-077	T2003-077	N/A	6.25		<u> </u>		<b> </b>	1	1	JET TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
	D2003-101	T2003-101	13.25	13.13				ļ	2	2		6061-T6 0.375 OD x 0.035 W	WW-T-600/6
	D2003-103	T2003-103	12.38	12.00	L		<u> </u>	<del> </del>	2	2	TUBE ASS'Y TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
	D2003-105	T2003-105	10.75	10.60			<b> </b>	ļ	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
	D2003-107	T2003-107	12.75	12.25				<del> </del>	2	2		6061-T6 0.500 OD x 0.035 W	WW-T-600/6
	D2003-109	T2003-109	8.25	8.125	ļ		2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
	D2003-111	T2003-111	4.75	4.625		ļ	2	2	ļ	<del> </del>	TUBE ASS'Y	M2650-20 CRINKLE-SOFT	STRATOFLEX
	D2003-116	T2003-116	4.0					<u> </u>	ļ		HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
	D2003-120	T2003-120	4.0	<u> </u>		ļ		<del> </del>			HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
	D2003-14	T2003-14	4.0				<b> </b>	<del> </del>	<b> </b>	<del> </del>	HEATSLEEVE HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
	D2003-16	T2003-16	4.0			ļ	<b> </b>	-	-		TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
	D2003-205	T2003-205	9.75	9.60			<u> </u>	<del> </del>	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
	D2003-207	T2003-207	3.75	3.75		ļ		<del> </del>	2	2	1 UBE A33 T		
		ļ				<del> </del>	<u> </u>	├		<del> </del>			f
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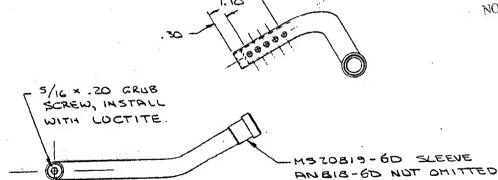




## Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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